

MAY 31 2018

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada



Tel (613) 632-5200

D350-591-213
Job Sheet 175685



004051

Part No: D350-591-213

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	10 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Stores/Pkg-2			JUN 25 2018
270	Packaging	10 pcs	7/13/18	7/13/18	0.00	0.00	Packaging1-3			JUN 25 2018
280	QC	10 pcs	7/13/18	7/13/18	0.00	0.00	QC4			
285	DC	10 pcs	7/13/18	7/13/18	0.00	0.00	DC			
290	Packaging	10 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-1			
300	QC21-FG	10 Ea	7/13/18	7/13/18	0.00	0.00	QC21			

Part Op 285 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005
Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-213

F9039

DAS
21
9-88

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	20 Ea (2 ea)	90-Start up Operation	5067891
AN4-15A	Bolt	40 Ea (4 ea)	90-Start up Operation	5057424
AN5-36A	Bolt	20 Ea (2 ea)	90-Start up Operation	2068650
D2230-3	Mounting Lug	20 Ea (2 ea)	90-Start up Operation	5085080
D2618	Bushing	20 Ea (2 ea)	90-Start up Operation	5049859
D2732-030	Rubber Cushion (\$Per Foot)	10 Ea (1 ea)	90-Start up Operation	5073491
D3078-041	Step Assembly, Hi Short LH	10 Ea (1 ea)	90-Start up Operation	5073491
D3235-1	Mounting Lug	20 Ea (2 ea)	90-Start up Operation	5069874
D3338-1	Mounting Lug	10 Ea (1 ea)	90-Start up Operation	5067891
MS21042L3	Nut	20 Ea (2 ea)	90-Start up Operation	5078167
MS21042L4	Nut	60 Ea (6 ea)	90-Start up Operation	5067891
MS21042L5	Nut	20 Ea (2 ea)	90-Start up Operation	5058178
NAS1149D0363J	Washer	40 Ea (4 ea)	90-Start up Operation	5015264
NAS1149D0463J	Washer	120 Ea (12 ea)	90-Start up Operation	5067800
NAS1149D0563J	Washer	40 Ea (4 ea)	90-Start up Operation	5068602

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	20	238	0
	AN4-15A	40	519	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION _____		AGAINST DEPARTMENT/PROCESS _____			
Date : _____		Step #: _____		Water let ☐ Engineering ☐ Quality ☐ Other ☐			
Description Work Order _____				MRB (QSI042) Approval _____			
_____				Completed By _____			
_____				Lead hand / Supervisor Approval Verification _____			
_____				QC / QA Coordinator Approval _____			

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DART
AEROSPACE

Container No: S083994
 Part: D350 - 591 - 213
 Job No: 175685
 Serial No/Batch: S083994
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 06/25/18

Root Cause			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____			

AN5-36A	20	208	0
D2230-3	20	155	0
D2618	20	402	0
D2732	10	509	0
D3078-041	10	0	0
D3235-1	20	232	0
D3338-1	10	33	0
MS21042L3	20	2,542	0
MS21042L4	60	3,623	0
MS21042L5	20	1,048	0
NAS1149D0363J	40	2,859	0
NAS1149D0463J	120	5,583	0
NAS1149D0563J	40	1,766	0

Part Specifications

Specifications could not be found.

Plex 4/10/18 9:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

REFERENCE ONLY

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY